

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

Claim 1. (Cancelled)

Claim 2. (Currently Amended) A vertical machining center, as claimed in claim 1 ~~5~~, wherein the workpiece feed comprises a magazine, the movement of which can be timed and which has a plurality of receivers for workpiece holders.

Claim 3. (Original) A vertical machining center, as claimed in claim 2, wherein the workpiece feed comprises a magazine wheel which carries the receivers and can be swiveled about a central axis.

Claim 4. (Cancelled)

Claim 5. (Currently Amended) A vertical machining center, ~~as claimed in claim 1, further comprising~~ comprising:

a tool slide which can be moved in a controlled manner;

a workpiece feed on one side of a machining area;

a moveable vertical machining center component that can be controlled in at least one axis to change workpieces between the workpiece feed and the machining area;

said workpiece feed being adapted to hold available and accept workpiece holders with workpieces and being mounted so as to be in alignment with a CNC rotary table on that side of the vertical machining center, on which the respective workpiece holder is held by the CNC rotary table, and wherein the CNC rotary table is movable on guides in a direction of the workpiece feed such that the CNC rotary table is directly contactable with the workpiece holders to change the workpiece holders; and

a counter-vise to hold the workpiece holder on the side, facing the workpiece feed and facing away from the CNC rotary table, said counter-vise being mounted so as to be traversable with the workpiece holder out of the collision area.

Claim 6. (Currently Amended) A vertical machining center, ~~as claimed in claim 1, further comprising~~ comprising:

a tool slide which can be moved in a controlled manner;

a workpiece feed on one side of a machining area;

a moveable vertical machining center component that can be controlled in at least one axis to change workpieces between the workpiece feed and the machining area;

said workpiece feed being adapted to hold available and accept workpiece holders with workpieces and being mounted so as to be in alignment with a CNC rotary table on that side of the vertical machining center, on which the respective workpiece holder is held by the CNC rotary table; and

a counter-vise that includes a holder for clamping the workpiece holder, which is designed for swiveling the respective workpiece holder 180° between a position facing the CNC rotary table and a position facing the workpiece feed, and the counter-vise is traversable on guides in the direction of the workpiece feed.

Claim 7. (Currently Amended) A vertical machining center, as claimed in ~~one of claims 1-3~~ claim 5, wherein to move the CNC rotary table or ~~a~~ the counter-vise, the tool slide and the CNC rotary table or the counter-vise have docking means.

Claim 8. (Currently Amended) A vertical machining center, ~~as claimed in one of claims 1-3,~~ comprising:

a tool slide which can be moved in a controlled manner;

a workpiece feed on one side of a machining area;

a moveable vertical machining center component that can be controlled in at least one axis to change workpieces between the workpiece feed and the machining area;

said workpiece feed being adapted to hold available and accept workpiece holders with workpieces and being mounted so as to be in alignment with a CNC rotary table on that side of the vertical machining center, on which the respective workpiece holder is held by the CNC rotary table; and

wherein the tool slide has a gripper to change the workpiece holders.

Claim 9. (New) A vertical machining center, as claimed in claim 6, wherein the workpiece feed comprises a magazine, the movement of which can be timed and which has a plurality of receivers for workpiece holders.

Claim 10. (New) A vertical machining center, as claimed in claim 9, wherein the workpiece feed comprises a magazine wheel which carries the receivers and can be swiveled about a central axis.

Claim 11. (New) A vertical machining center, as claimed in claim 6, wherein to move the CNC rotary table or the counter-vise, the tool slide and the CNC rotary table or the counter-vise have docking means.

Claim 12. (New) A vertical machining center, as claimed in claim 8, wherein the workpiece feed comprises a magazine, the movement of which can be timed and which has a plurality of receivers for workpiece holders.

Claim 13. (New) A vertical machining center, as claimed in claim 12, wherein the workpiece feed comprises a magazine wheel which carries the receivers and can be swiveled about a central axis.

Claim 14. (New) A vertical machining center, as claimed in claim 8, wherein to move the CNC rotary table or a counter-vise, the tool slide and the CNC rotary table or the counter-vise have docking means.